

Work Order ID: 76853

76853

Page 1

November-22-11 10:54:18 AM

Item ID: D3043-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Step Weldment RH, A119

Start Date: 22/11/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 06/12/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: M.C.J

Date: 11/11/22 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3043

Rev A

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G
2-Deburr and bevel ends for welding

110

0.00

110

QC

QC6- Inspect dimensions to drawing

Memo

0.00

Quality Control

120

0.00

120

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8808
AR AL ROD Batch: 114514
2-Grind Fwd End Cap weld flush 118735

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76853

76853

Page 2

November-22-11 10:54:18 AM

Item ID: D3043-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment RH, A119
 Start Date: 22/11/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 06/12/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				H	0	BE11-12-14	
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8-12/16		x4 RH			
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				(4)		11-12-16	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76853

76853

Page 3

November-22-11 10:54:18 AM

Item ID: D3043-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment RH, A119
 Start Date: 22/11/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 06/12/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Large Fab	Large Fab	0.00							
Large Fab	Memo 1-1-Weld 1 End Cap as per QSI 004 & Dwg AR AL ROD Batch: <u>M1145/4</u> 2-Inspect for foreign object as per QSI 024 3-Grind Fwd End Cap weld flush	0.00							
170 *170* QC	QC10- Inspect visual per QSI004- ground welds	0.00							
Quality Control	Memo	0.00							
180 *180* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76853

76853

Page 4

November-22-11 10:54:18 AM

Item ID: D3043-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment RH, A119
 Start Date: 22/11/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 06/12/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190	Chemical Conversion Coat per QSI005 4.1	0.00							
-----	---	------	--	--	--	--	--	--	--

190									
HandFinish	Memo	0.00							
Hand Finishing									

4xØ M-L 11/12/11

200	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--

200									
QC	Memo	0.00							
Quality Control									

N/A

210	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

210									
Powdercoat	Memo	0.00							
Powder Coating									

START Time: *8:30*
 OVEN TEMPERATURE: *320 °F*
 FINISH TIME: *9:00*

4xØ M-L 11/12/11

M119480

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76853

76853

Page 5

November-22-11 10:54:18 AM

Item ID: D3043-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Weldment RH, A119
Start Date: 22/11/2011 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 06/12/2011 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	Wing Walk as per dwg QSI005 4.4 Batch <i>119021</i>	0.00							
220	HandFinish	Memo							
Hand Finishing									
230	QC3- Inspect Part Finish	0.00							
230	QC	Memo							
Quality Control									
240	Identify as per dwg & Stock Location: _____	0.00							
240	Packaging	Memo							
Packaging									

H. 15R 11-12-21

4RH 6 11/12/21
counted & id.

[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76853***76853***

Page 6

November-22-11 10:54:18 AM

Item ID: D3043-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Step Weldment RH, A119

Start Date: 22/11/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 06/12/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

QC21- Final Inspection - Work Order Release

0.00


250

QC

Memo

0.00

Quality Control

11/12/22 
MF
11-12-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-22-11 10:54:22 AM

Page 1

Work Order ID: 76853

76853

Parent Item: D3043-042

D3043-042

Parent Item Name: Step Weldment RH, A119

Start Date: 22/11/2011

Required Date: 06/12/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev :A New Issue JLM 05-11-01

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured

No

100

Each

28.0200

1

4

D2622-120C

Step Extrusion

**

11.12.01

Location

Loc Qty

Loc Code

HALL

B75781

18.32

64409

6

68293

0.5

72131

11.82

WA

9.7

46910

2

66970

7.7

4

D2734

Manufactured

No

120

Each

41.0000

1

4

D2734

Step End Plate

**

11.12.13

Location

Loc Qty

Loc Code

WA

41

73416

41

4

D3040-1

Manufactured

No

120

Each

18.0000

2

8

D3040-1

Mounting Lug

**

11.12.13

Location

Loc Qty

Loc Code

WA018

18

48239

18

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-22-11 10:54:22 AM

Page 2

Work Order ID: 76853

76853

Parent Item: D3043-042

D3043-042

Parent Item Name: Step Weldment RH, A119

Start Date: 22/11/2011

Required Date: 06/12/2011

Start Qty: 4.00

Required Qty: 4.00

D3040-3

Manufactured No

120

Each

14.0000

2

8

D3040-3

Mounting Lug

**

11.12.13

Location

Loc Qty

Loc Code

WA018

316998

14

48240

14

D2734

Manufactured No

160

Each

41.0000

1

4

D2734

Step End Plate

**

11.12.13

Location

Loc Qty

Loc Code

WA

73416

41

41

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3043	REV. A SHEET 1 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE NTS
A	01.06.28	NEW ISSUE	

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D3043-041	STEP WELDMENT, LH
	X	D3043-042	STEP WELDMENT, RH
1	1	D2622-120	STEP EXTRUSION
2	2	D3040-1	MOUNTING LUG
2	2	D3040-3	MOUNTING LUG
2	2	D2734	ENDPLATE

NOTES:

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 76853 M.L.J

11/11/22

RELEASED
01.07.05 *[Signature]*

Copyright © 2001 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

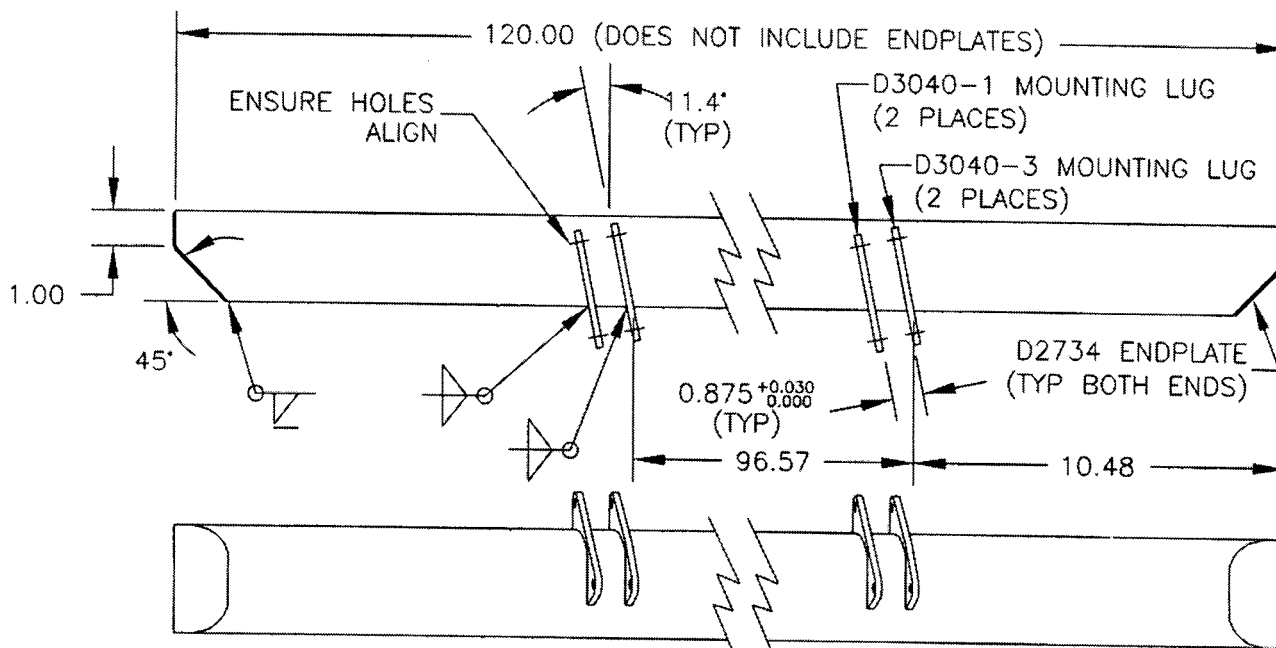
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

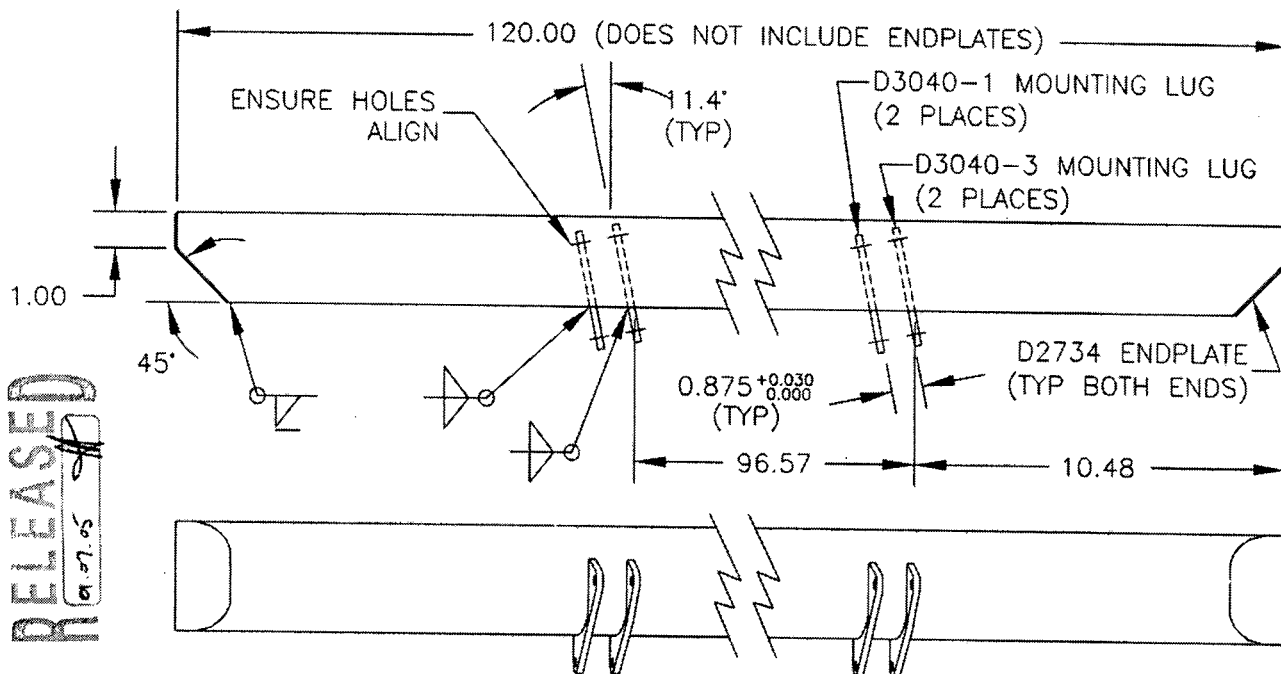


76853

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3043	REV. A SHEET 2 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE 1:5
A	01.06.28	NEW ISSUE	



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

Copyright © 2001 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

RELEASED
5010105

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries